Work Order ID 74596

Monday, October 03, 2011 3:59:20 PM

ASAP

Item ID: D3794-3

Revision ID:

Item Name: Gasket

Accept

Setup **Start** / **Stop**

Start Date: 10/3/2011 **Start Qty:** 12.00

Required Date: 10/5/2011 **Req'd Qty:** 12.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ✓ **Date:** 11-10-09 **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run **Start** / **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3794	**Revision Nbr** Rev A								
100 Waterjet FLOW CNC Waterjet	FLOW WATER JET **Memo** 1-Cut as per Dwg D3794 ☐Dwg Rev: A ☐Prog Rev: A ☐2-Deburr if necessary	0.00 0.00				B11-10-11			
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				B11-10-11			
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00				W 11	10	12	(4)

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74596

Monday, October 03, 2011 3:59:20 PM

Item ID: D3794-3 **Accept**

Setup **Start** **Stop**

Revision ID:

Item Name: Gasket

Start Date: 10/3/2011 **Start Qty:** 12.00 **Cust Item ID:**

Required Date: 10/5/2011 **Req'd Qty:** 12.00 **Customer:**

Reference:

Run **Start** **Stop**

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: ST FP	0.00	8	14	11-10	13			
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00					11/10/13		
QC	Memo	0.00							
Quality Control									

MF 11-10-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ___________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Monday, October 03, 2011 3:59:25 PM

Work Order ID: 74596

Parent Item: D3794-3

Parent Item Name: Gasket

Start Date: 10/3/2011 **Required Date:** 10/5/2011

Start Qty: 12.00 **Required Qty:** 12.00

Comments:
IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 NEOPRENE SHEET 0.063		Purchased	No			100	sf	636.8500	1.2828	17.104 B11-1041			

Location	Loc Qty	Loc Code	
MAT052	636.85		
117295	55.68		
118026	127.87		
118663	73.3		118663
119130	380		

(12)

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ______________ **Disposition:** ______________ **QA: N/C Closed:** _________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74596
Description: Gasket	Part Number:	D3794-3
Inspection Dwg: D3794 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.192	✓		V B02	
0.300 x 0.300	+/-0.010	308 x 306	✓		V	
1.88	+/-0.030	1.891	✓		V	
4.281	+/-0.010	4.283	✓		T B01	
6.44	+/-0.030	6.424	✓		T	
6.00	+/-0.030	6.00	✓		T	
6.75	+/-0.030	6.75	✓		T	
2.00	+/-0.030	2.00	✓		T	
4.75	+/-0.030	4.75	✓		T	
9.50	+/-0.030	9.50	✓		T	
14.25	+/-0.030	14.28	✓		T	
17.75	+/-0.030	17.75	✓		T	
26.74	+/-0.030	26.74	✓		T	
29.23	+/-0.030	29.23	✓		T	

Measured by:	PB	Audited by:	[signature]	Prototype Approval:	N/A
Date:	11-10-11	Date:	11.10.12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	
B	08.10.17	17.75 revised per Dwg Rev. A	KJ/DD [initials]	[initials]

Dart Aerospace Ltd

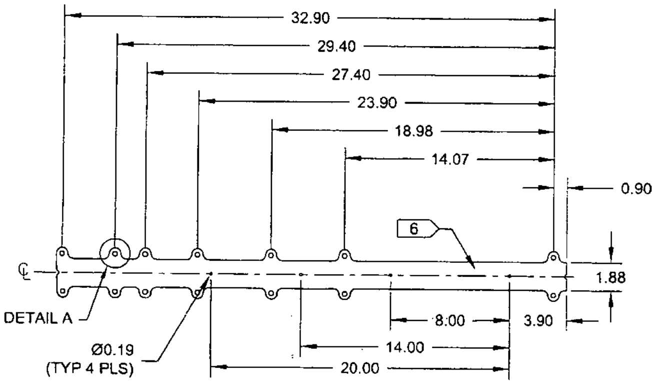
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

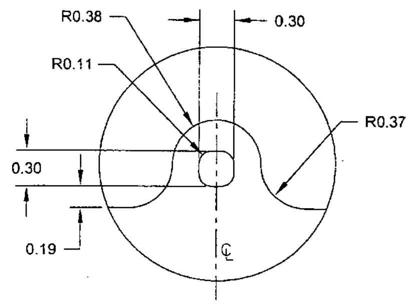
Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

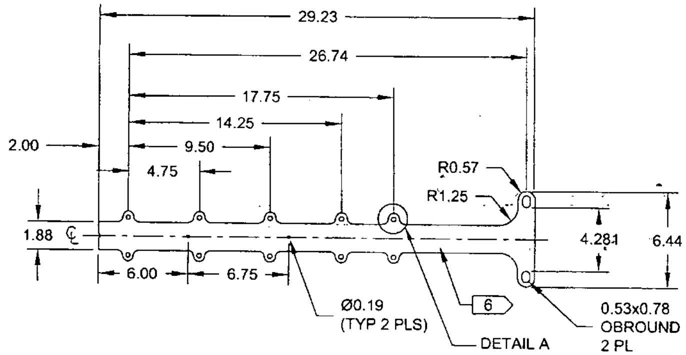


D3794-1 GASKET



DETAIL A
SCALE 8X

74594
11-10-04



D3794-3 GASKET

NOTES:

1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER
(REF DART SPEC. M-NEO60-S.063)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	PH	08.05.14

DESIGN	PH	**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN	PH	
CHECKED		DRAWING NO. D3794 — REV. A — SHEET 1 OF 1
MFG. APPR.		
APPROVED		TITLE GASKET — SCALE NTS
DE APPR.		
DATE	08.05.14	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

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